

Work Order ID 61799

Friday, September 03, 2010 1:41:44 PM



Page 1

Item ID: D3975-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Cylinder Assembly, RH

Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*M*Date: *10-9-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3975

B

110

0.00



Small Fab

Memo

0.00

Small Fab

apply decal as per dwg

*JB 10/09/20**(4)*

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*S. 10/09/20**(4)*

130

0.00



Packaging

Identify as per dwg & Stock Location: *105*

Memo

0.00

Packaging

10/9/20 (4) [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30

MF
10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, September 03, 2010 1:41:49 PM

Page 1

Work Order ID: 61799



Parent Item: D3975-042



Parent Item Name: Gas Cylinder Assembly, RH

Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
10.05.27 as per ECN10-548 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3975-1		Manufactured	No			110	Each	2.0000	1	4			
Gas Cylinder													

Location Loc Qty Loc Code

FG 61800 2 (4)

59815 2

D3976-3		Manufactured	No			110	Each	12.0000	1	4			
Decal													

Location Loc Qty Loc Code

ST105 10

60431 10 2

ST139 2

52630 2 2

SA 10/09/28

(4)

5

SA 10/09/28

(4)

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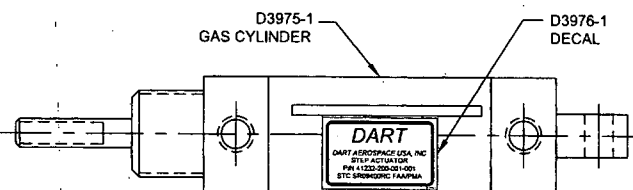
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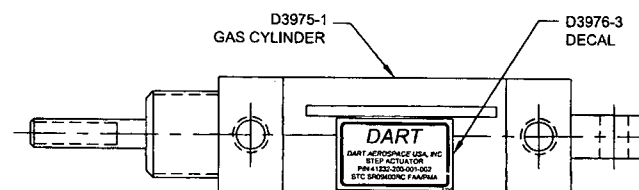
NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 ^Δ	DECAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *46799*
RD-9-02



D3975-041 GAS CYLINDER ASSEMBLY



D3975-042 GAS CYLINDER ASSEMBLY

RELEASED
2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1).	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AJS</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3975	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

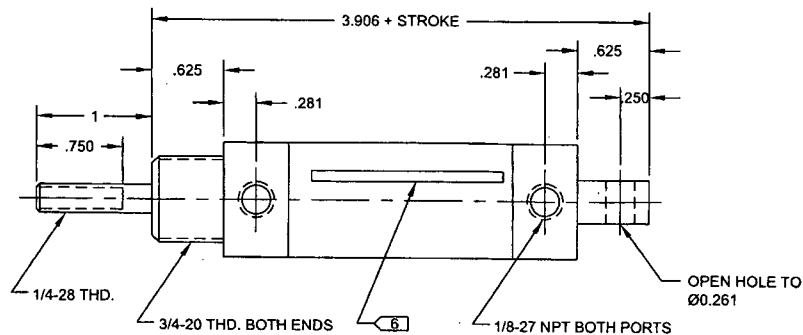
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D3975-1 BRASS CYLINDER

NOTES:

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.875 INCHES
- 3) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2680 PSI (USE 5606 FLUID).

RELEASED
R 2010-05-20

DESIGN	AYS	DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3975	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GAS CYLINDER ASSEMBLY	NTS
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